

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order:		DISPOSITION				AGAINST DEPARTMENT/PROCESS						
Part No.		Rework	Skid-tube	Crosstube	Water Jet	Engineering						
NCR No.		Scrap	Machining	Small Fab	Prod. Eng. Coor.	Quality						
		Use-as-is	Thermoforming	Finishing	Rec/Store/Packaging	Other						
		Work Order Update	Large Fab	Composite	Supplier							
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector			
Doc/Data												
Equip/Tooling												
Operator												
Material												
Setup												
Other												
Process												
Supplier												
Training												
Unapproved												
FAULT CATEGORY												
Landing Gear		General										
Bending		Bend		Grain		Ovalized		Pressure/Forced				
Centre Not Concentric to O/S		BOM/Route		Hardware		Over/Under tolerance		Temperature/Cure				
Cracks		Broken/Damaged		Inspection Incomplete		Part Incorrect		Weld				
Crushed/Crimped.		Burrs		Instructions Incomplete/Unclear		Part Lost/Missing		Wrong Stock Pulled				
Cuffs		Contamination		Maintenance		Part Moved						
Heat Treat		Countersink		Mislabeled		Positioned Wrong						
Inspection Strip in Tube		Cut Too Short		Misread		Power Loss/Surge		Other				
Ripples in Bend		Drill Holes		Offset								
Torque Waves in Extrusion		Drawing		Out of Calibration								
Turning Sequence		Finish		Out of Sequence								
Wave/Twist in Tube		Folio		Outside Dimensions								

Work Order ID 97814

97814

Page 2

February 27, 2013 10:10:29 AM

Item ID: D2230-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Lug

Stop

NS2

Start Date: 2/27/13

Start Qty: 200.00

200

Cust Item ID:

Required Date: 3/15/13

Req'd Qty: 200.00

200

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:		Stop	*NR2*

Sequence # Work Center, ID	Operation Description	SW Hours	W Hours	Job #	Plan Code	Accept Qty	Reject Qty	Reject Number	Inspe. Stamp
120 <i>QC1</i> <i>*120*</i> QC Quality Control	QC2-Inspect parts off machine FAI/FAIB	0.00							

130 <i>QC2</i> <i>*130*</i> QC Quality Control	Memo	0.00							
--	------	------	--	--	--	--	--	--	--

load + inspect
~~make inspection~~ & attach C of C to WO

130 <i>QC2</i> <i>*130*</i> QC Quality Control	QC8- Inspect parts - second check	0.00	<i>Shr</i> <i>B310</i>	200 <i>clear</i>					
--	-----------------------------------	------	---------------------------	---------------------	--	--	--	--	--

140 <i>HandFinish</i> Hand Finishing	Chemical Conversion Coat per QSI005 4.1	0.00		200 <i>133-13</i>					
--	---	------	--	----------------------	--	--	--	--	--

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order:		DISPOSITION				AGAINST DEPARTMENT/PROCESS					
		Rework	<input type="checkbox"/>	Skid-tube	<input type="checkbox"/>	Crosstube	<input type="checkbox"/>	Water Jet	<input type="checkbox"/>	Engineering	
		Scrap	<input type="checkbox"/>	Machining	<input type="checkbox"/>	Small Fab	<input type="checkbox"/>	Prod. Eng. Coor.	<input type="checkbox"/>	Quality	
		Use-as-is	<input type="checkbox"/>	Thermoforming	<input type="checkbox"/>	Finishing	<input type="checkbox"/>	Rec/Store/Packaging	<input type="checkbox"/>	Other	
		Work Order Update	<input type="checkbox"/>	Large Fab	<input type="checkbox"/>	Composite	<input type="checkbox"/>	Supplier	<input type="checkbox"/>		
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear	General										
	Bending	<input type="checkbox"/>	Grain	<input type="checkbox"/>	Ovalized	<input type="checkbox"/>	Pressure/Forced				
	Centre Not Concentric to O/S	<input type="checkbox"/>	BOM/Route	<input type="checkbox"/>	Over/Under tolerance	<input type="checkbox"/>	Temperature/Cure				
	Cracks	<input type="checkbox"/>	Broken/Damaged	<input type="checkbox"/>	Part Incorrect	<input type="checkbox"/>	Weld				
	Crushed/Crimped.	<input type="checkbox"/>	Burrs	<input type="checkbox"/>	Part Lost/Missing	<input type="checkbox"/>	Wrong Stock Pulled				
	Cuffs	<input type="checkbox"/>	Contamination	<input type="checkbox"/>	Part Moved	<input type="checkbox"/>					
	Heat Treat	<input type="checkbox"/>	Countersink	<input type="checkbox"/>	Positioned Wrong	<input type="checkbox"/>					
	Inspection	<input type="checkbox"/>	Cut Too Short	<input type="checkbox"/>	Power Loss/Surge	<input type="checkbox"/>	Other				
	Strip in Tube	<input type="checkbox"/>	Drill Holes	<input type="checkbox"/>		<input type="checkbox"/>					
	Ripples in Bend	<input type="checkbox"/>	Drawing	<input type="checkbox"/>		<input type="checkbox"/>					
	Torque Waves in Extrusion	<input type="checkbox"/>	Finish	<input type="checkbox"/>		<input type="checkbox"/>					
	Turning Sequence	<input type="checkbox"/>	Folio	<input type="checkbox"/>		<input type="checkbox"/>					
	Wave/Twist in Tube	<input type="checkbox"/>		<input type="checkbox"/>		<input type="checkbox"/>					
				<input type="checkbox"/>		<input type="checkbox"/>					
				<input type="checkbox"/>		<input type="checkbox"/>					

Work Order ID 97814

February 27, 2013 10:10:29 AM

97814

Page 3

Item ID: D2230-1

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Lug

Stop

NS2

Start Date: 2/27/13

Start Qty: 200.00

200

Cust Item ID:

Required Date: 3/15/13

Req'd Qty: 200.00

200

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

150

150

QC

Quality Control

Operation
Description

QC3- Inspect Part Finish

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200X Ø MF 13/04/01

160

160

Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

1-30

0.00

START TIME:

320 30=

OVEN TEMPERATURE:

FINISH TIME:

200X Ø MF 13/04/02

170

170

QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

2-50

0.00

200 Ø B-4-2



NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order:			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework	Skid-tube	Crosstube	Water Jet	Engineering				
			Scrap	Machining	Small Fab	Prod. Eng. Coor.	Quality				
			Use-as-is	Thermoforming	Finishing	Rec/Store/Packaging	Other				
			Work Order Update	Large Fab	Composite	Supplier					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear	Bending	General	Bend	Grain	Ovalized	Pressure/Forced					
	Centre Not Concentric to O/S		BOM/Route	Hardware	Over/Under tolerance	Temperature/Cure					
	Cracks		Broken/Damaged	Inspection Incomplete	Part Incorrect	Weld					
	Crushed/Crimped.		Burrs	Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled					
	Cuffs		Contamination	Maintenance	Part Moved						
	Heat Treat		Countersink	Mislabeled	Positioned Wrong						
	Inspection Strip in Tube		Cut Too Short	Misread	Power Loss/Surge	Other					
	Ripples in Bend		Drill Holes	Offset							
	Torque Waves in Extrusion		Drawing	Out of Calibration							
	Turning Sequence		Finish	Out of Sequence							
	Wave/Twist in Tube		Folio	Outside Dimensions							

Work Order ID 97814

97814

Page 4

February 27, 2013 10:10:29 AM

Item ID: D2230-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Lug

Stop

NS2

Start Date: 2/27/13

Start Qty: 200.00

200

Cust Item ID:

Required Date: 3/15/13

Req'd Qty: 200.00

200

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID
180

Operation
Description
Identify as per dwg & Stock Location

Set Up/
Run Hours
ST 469 0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

Packaging

Packaging

Memo

0.00

200X

SP
13-4-10

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Quality Control

Memo

0.00

13/4/10 JJ

cme

13-4-10

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order:		DISPOSITION			AGAINST DEPARTMENT/PROCESS						
		Rework	<input type="checkbox"/>	Skid-tube	<input type="checkbox"/>	Crosstube	<input type="checkbox"/>	Water Jet	<input type="checkbox"/>	Engineering	<input type="checkbox"/>
Part No.		Scrap	<input type="checkbox"/>	Machining	<input type="checkbox"/>	Small Fab	<input type="checkbox"/>	Prod. Eng. Coor.	<input type="checkbox"/>	Quality	<input type="checkbox"/>
NCR No.		Use-as-is	<input type="checkbox"/>	Thermoforming	<input type="checkbox"/>	Finishing	<input type="checkbox"/>	Rec/Store/Packaging	<input type="checkbox"/>	Other	<input type="checkbox"/>
		Work Order Update	<input type="checkbox"/>	Large Fab	<input type="checkbox"/>	Composite	<input type="checkbox"/>	Supplier	<input type="checkbox"/>		
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Turning Sequence Wave/Twist in Tube			General							
				Bend	<input type="checkbox"/>	Grain	<input type="checkbox"/>	Ovalized	<input type="checkbox"/>	Pressure/Forced	
				BOM/Route	<input type="checkbox"/>	Hardware	<input type="checkbox"/>	Over/Under tolerance	<input type="checkbox"/>	Temperature/Cure	
				Broken/Damaged	<input type="checkbox"/>	Inspection Incomplete	<input type="checkbox"/>	Part Incorrect	<input type="checkbox"/>	Weld	
				Burrs	<input type="checkbox"/>	Instructions Incomplete/Unclear	<input type="checkbox"/>	Part Lost/Missing	<input type="checkbox"/>	Wrong Stock Pulled	
				Contamination	<input type="checkbox"/>	Maintenance	<input type="checkbox"/>	Part Moved	<input type="checkbox"/>		
				Countersink	<input type="checkbox"/>	Mislabeled	<input type="checkbox"/>	Positioned Wrong	<input type="checkbox"/>		
				Cut Too Short	<input type="checkbox"/>	Misread	<input type="checkbox"/>	Power Loss/Surge	<input type="checkbox"/>	Other	
				Drill Holes	<input type="checkbox"/>	Offset	<input type="checkbox"/>		<input type="checkbox"/>		
				Drawing	<input type="checkbox"/>	Out of Calibration	<input type="checkbox"/>		<input type="checkbox"/>		
				Finish	<input type="checkbox"/>	Out of Sequence	<input type="checkbox"/>		<input type="checkbox"/>		
				Folio	<input type="checkbox"/>	Outside Dimensions	<input type="checkbox"/>		<input type="checkbox"/>		
					<input type="checkbox"/>		<input type="checkbox"/>		<input type="checkbox"/>		
					<input type="checkbox"/>		<input type="checkbox"/>		<input type="checkbox"/>		
					<input type="checkbox"/>		<input type="checkbox"/>		<input type="checkbox"/>		

Picklist Print

February 27, 2013 10:10:29 AM

Page 1

Work Order ID: 97814

Parent Item: D2230-1

Parent Item Name: Lug

Start Date: 2/27/13

Required Date: 3/15/13

Start Qty: 200.00

Required Qty: 200.00

Comments: IPP D00.11.01Added inspection level 8, and removed P/O for powder coatEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2230-1P LUG		Purchased	No				Each	0.0000		200		2/27/13 (200)	
D2423 Lug Extrusion		Manufactured	No		110	f		679.3700	0.0683	14.378947		Call 3/02/12	

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	MAT006	383	
	43722	161.5	
	87953	221.5	
	Metec 93551	296.37 296.37	14.38

NCR: Yes / No

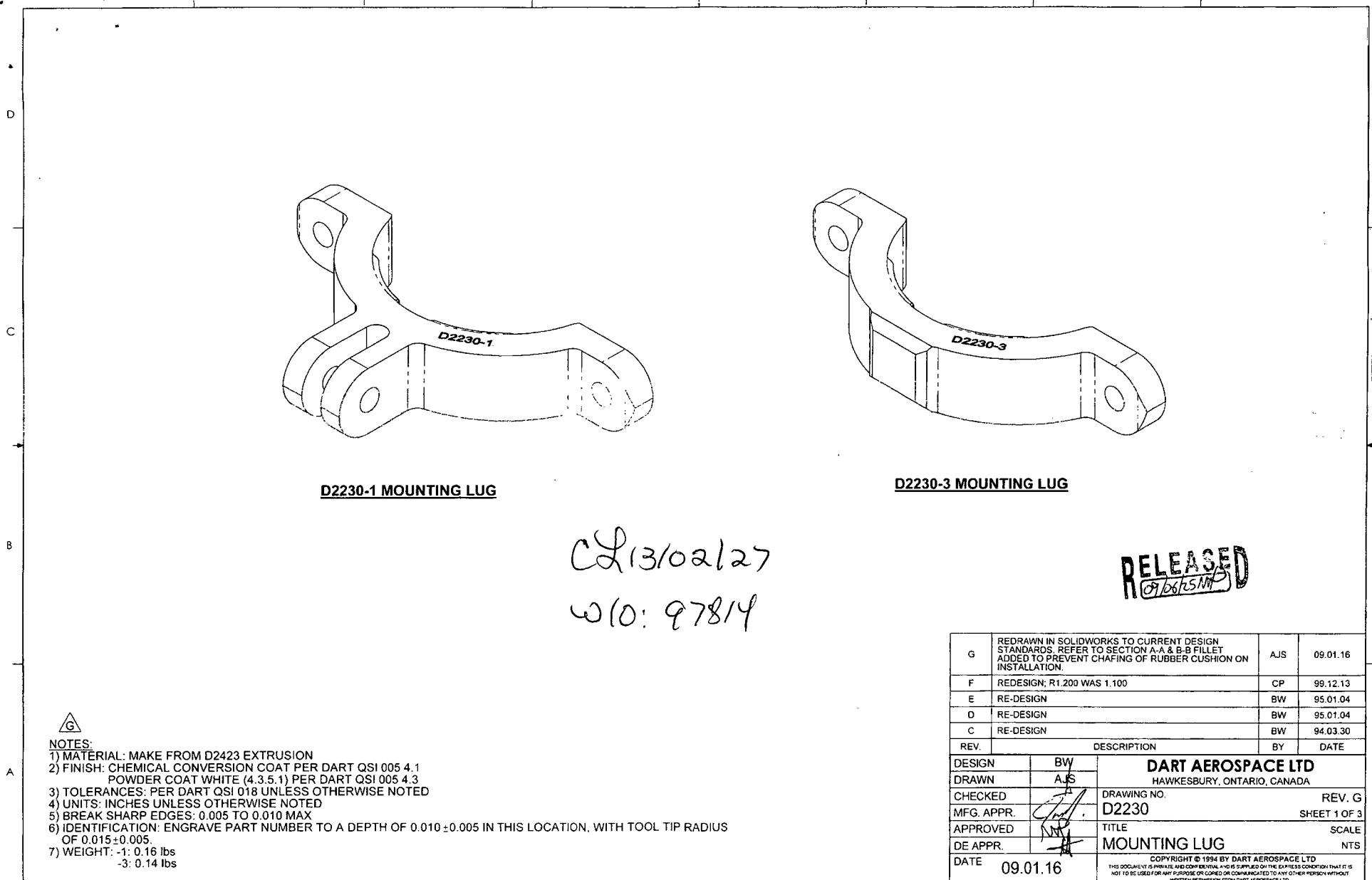
WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order:		DISPOSITION			AGAINST DEPARTMENT/PROCESS						
		Rework	<input type="checkbox"/>	Skid-tube	<input type="checkbox"/>	Crosstube	<input type="checkbox"/>	Water Jet	<input type="checkbox"/>	Engineering	<input type="checkbox"/>
		Scrap	<input type="checkbox"/>	Machining	<input type="checkbox"/>	Small Fab	<input type="checkbox"/>	Prod. Eng. Coor.	<input type="checkbox"/>	Quality	<input type="checkbox"/>
		Use-as-is	<input type="checkbox"/>	Thermoforming	<input type="checkbox"/>	Finishing	<input type="checkbox"/>	Rec/Store/Packaging	<input type="checkbox"/>	Other	<input type="checkbox"/>
		Work Order Update	<input type="checkbox"/>	Large Fab	<input type="checkbox"/>	Composite	<input type="checkbox"/>	Supplier	<input type="checkbox"/>		
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
	Bending	<input type="checkbox"/>	Bend	<input type="checkbox"/>	Grain	<input type="checkbox"/>	Ovalized	<input type="checkbox"/>	Pressure/Forced		
	Centre Not Concentric to O/S	<input type="checkbox"/>	BOM/Route	<input type="checkbox"/>	Hardware	<input type="checkbox"/>	Over/Under tolerance	<input type="checkbox"/>	Temperature/Cure		
	Cracks	<input type="checkbox"/>	Broken/Damaged	<input type="checkbox"/>	Inspection Incomplete	<input type="checkbox"/>	Part Incorrect	<input type="checkbox"/>	Weld		
	Crushed/Grimped.	<input type="checkbox"/>	Burrs	<input type="checkbox"/>	Instructions Incomplete/Unclear	<input type="checkbox"/>	Part Lost/Missing	<input type="checkbox"/>	Wrong Stock Pulled		
	Cuffs	<input type="checkbox"/>	Contamination	<input type="checkbox"/>	Maintenance	<input type="checkbox"/>	Part Moved	<input type="checkbox"/>			
	Heat Treat	<input type="checkbox"/>	Countersink	<input type="checkbox"/>	Mislabeled	<input type="checkbox"/>	Positioned Wrong	<input type="checkbox"/>			
	Inspection Strip in Tube	<input type="checkbox"/>	Cut Too Short	<input type="checkbox"/>	Misread	<input type="checkbox"/>	Power Loss/Surge	<input type="checkbox"/>	Other		
	Ripples in Bend	<input type="checkbox"/>	Drill Holes	<input type="checkbox"/>	Offset	<input type="checkbox"/>		<input type="checkbox"/>			
	Torque Waves in Extrusion	<input type="checkbox"/>	Drawing	<input type="checkbox"/>	Out of Calibration	<input type="checkbox"/>		<input type="checkbox"/>			
	Turning Sequence	<input type="checkbox"/>	Finish	<input type="checkbox"/>	Out of Sequence	<input type="checkbox"/>		<input type="checkbox"/>			
	Wave/Twist in Tube	<input type="checkbox"/>	Folio	<input type="checkbox"/>	Outside Dimensions	<input type="checkbox"/>		<input type="checkbox"/>			

8 7 6 5 4 3 2 1



D2230-1 MOUNTING LUG

D2230-3 MOUNTING LUG

CL(3/02/27
WTO: 97814

RELEASED
09/06/15 NM

G

NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005.
- 7) WEIGHT: -1: 0.16 lbs
-3: 0.14 lbs

REV.	DESCRIPTION	BY	DATE
G	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.	AJS	09.01.16
F	REDESIGN; R1.200 WAS 1.100	CP	99.12.13
E	RE-DESIGN	BW	95.01.04
D	RE-DESIGN	BW	95.01.04
C	RE-DESIGN	BW	94.03.30
DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
DATE	09.01.16	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

8

7

6

5

4

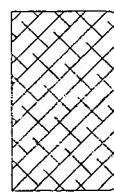
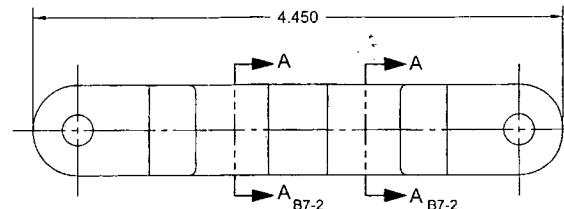
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2

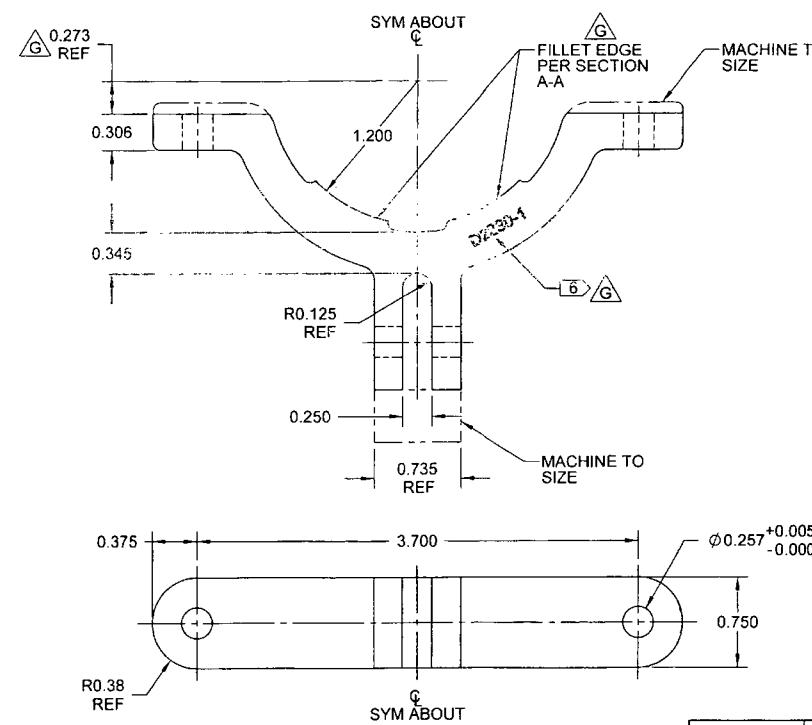
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D

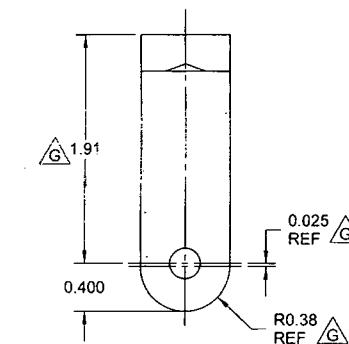
D



SECTION A-A D4-2
SCALE 2X



D2230-1 MOUNTING LUG



RELEASED
(09/06/25/16)

DESIGN	BW	DART AEROSPACE LTD
DRAWN	AIS	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO.
MFG. APPR.		D2230
APPROVED		REV. G
DE APPR.		SHEET 2 OF 3
DATE	09.01.16	TITLE
		SCALE
		NTS

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C

C

B

B

A

A

8

7

6

5

4

3

2

1

D

D

C

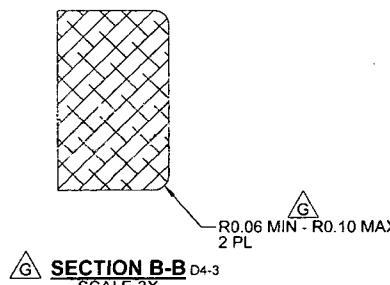
C

B

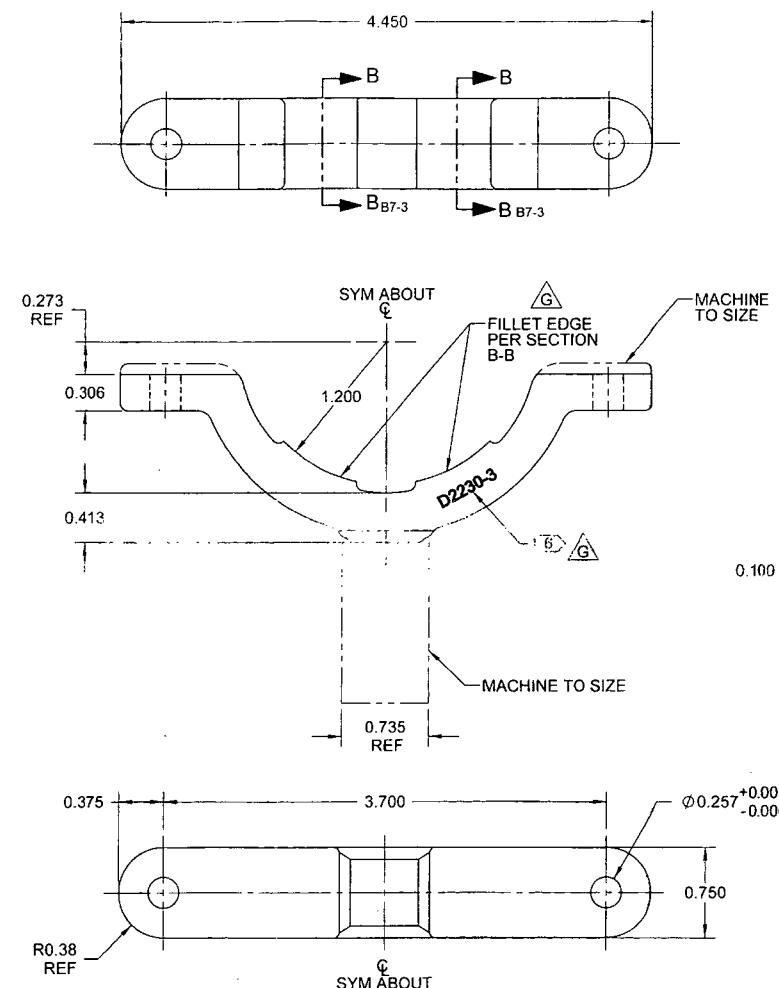
B

A

A



SECTION B-B D4-3
SCALE 2X



RELEASED
07/06/2016

DESIGN	BW	DART AEROSPACE LTD
DRAWN	AS	HAWKESBURY, ONTARIO, CANADA
CHECKED		REV. G
MFG. APPR.		D2230
APPROVED		SHEET 3 OF 3
DE APPR.		TITLE
DATE	09.01.16	SCALE
		NTS
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20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No:

18982

Mar 07, 2013

Date:

Page:

Sold to:	Ship to:
Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 19194	Sold By: Dewar Eric
Shipped By: your truck	Ship Date: Mar 08, 2013

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2731-7 LUG as per drawing D2731 REV. C B93551	Each	40	40	
D4091-1 Lug as per drawing D4091 Rev.A B93551	Each	40	40	
D2230-1 Mounting Lug as per drawing D2230 REV. G B93551	Each	200	200	
D2230-3 Mounting Lug as per drawing D2230 REV. G B93551	Each	100	100	

The delivered goods must be inspected upon receipt to confirm compliance.
Should there be discrepancies please notify METEC within 30 days of delivery.
The goods are otherwise deemed accepted.

Received by _____

Thank you for your order!



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0
Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
40	D2731-7	Lug	PO 19194
40	D4091-1	Lug	PO 19194
200	D2230-1	Mounting Lug	PO 19194
100	D2230-3	Mounting Lug	PO 19194

MATERIAL: supplied by DART B93551

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

A handwritten signature in black ink, appearing to read "Jan Norris".

Jan Norris